

5/26

SPLIT

DART AEROSPACE LTD	Work Order:	23552
Description: Battery Lock Casing	Part Number:	D3393-1
Dwg: D3393 Rev. A page 2	Qty:	50 18
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.06.10	50
2	MV	Cut blank: 1.500" x 1.500" x 3.125" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.500x01.500) Identify for D3393-1 Batch: M16754	J.L	15/06/10	
3	MV	Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1	En	05/06/12	51 Pto
4	QC2	Inspect parts as they come off the CNC machine	En	05/06/12	51
5	QC8	Second check	En	05.06.15	51
6	MV	Deburr	En	05/06/12	51
7	QC5	Inspect work to Step 6	En	05.06.15	51
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.06.20	51
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	FC	05.06.20	51
10	QC3	Inspect Powder Coat	ML	05.06.20	51
11	ST	Identify and Stock	CL	05/07/04	18
12	AC	Cost / part 7.53	AP	05/07/05	18
13	DC	Close W/O 7.47 Inspect Level 21	KJ	05.07.15	18

Rev	Date	Change	Revised By	Approved
A	05.02.18	New issue	KJ/JLM	

RELEASED  
11/05.02.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: <i>N/A</i>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
<i>05/06/11</i>	<i>#3</i>	<i>1 part scrap. Part came out of use</i>	<i>[Signature]</i>	<i>destroy &amp; replace</i>	<i>[Signature]</i> <i>05/06/13</i>	<i>[Signature]</i> <i>05/07/13</i>	<i>[Signature]</i>	<i>[Signature]</i> <i>05/06/13</i>

Part No: D3393-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: [Signature] Date: 05.07.15

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DART AEROSPACE LTD		Work Order:	23552
Description: Battery Lock Casing		Part Number:	D3393-1
Inspection Dwg: D3393 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	0.750	✓			
0.625	+/-0.010	0.628	✓			
Ø1.250	+/-0.010	1.244	✓			
1.088	+/-0.010	1.090	✓			
Ø0.734	+/-0.010	0.734	✓			
2.658	+/-0.010	2.658	✓			
1.550	+/-0.010	1.548	✓			
0.125 x 45°	+/-0.010	0.125 x 45°	✓			
1.50	+/-0.030	1.491	✓			
0.750	+/-0.010	0.743	✓			
Ø1.050	+/-0.010	1.060	✓			
Ø1.000	+/-0.010	0.998	✓			
0.338	+/-0.010	0.337	✓			
0.563	+/-0.010	0.567	✓			
0.100	+0.000/-0.010	0.098	✓			
3.00	+/-0.030	3.002	✓			
1.500	+/-0.010	1.496	✓			
0.375	+/-0.010	0.372	✓			
1.25	+/-0.030	1.252	✓			
0.125	+/-0.010	0.125	✓			
30°	0.5°	30°	✓			

Measured by:	EN	Audited by:	BC	Prototype Approval:	N/A
Date:	05/06/11	Date:	05/06/11	Date:	N/A

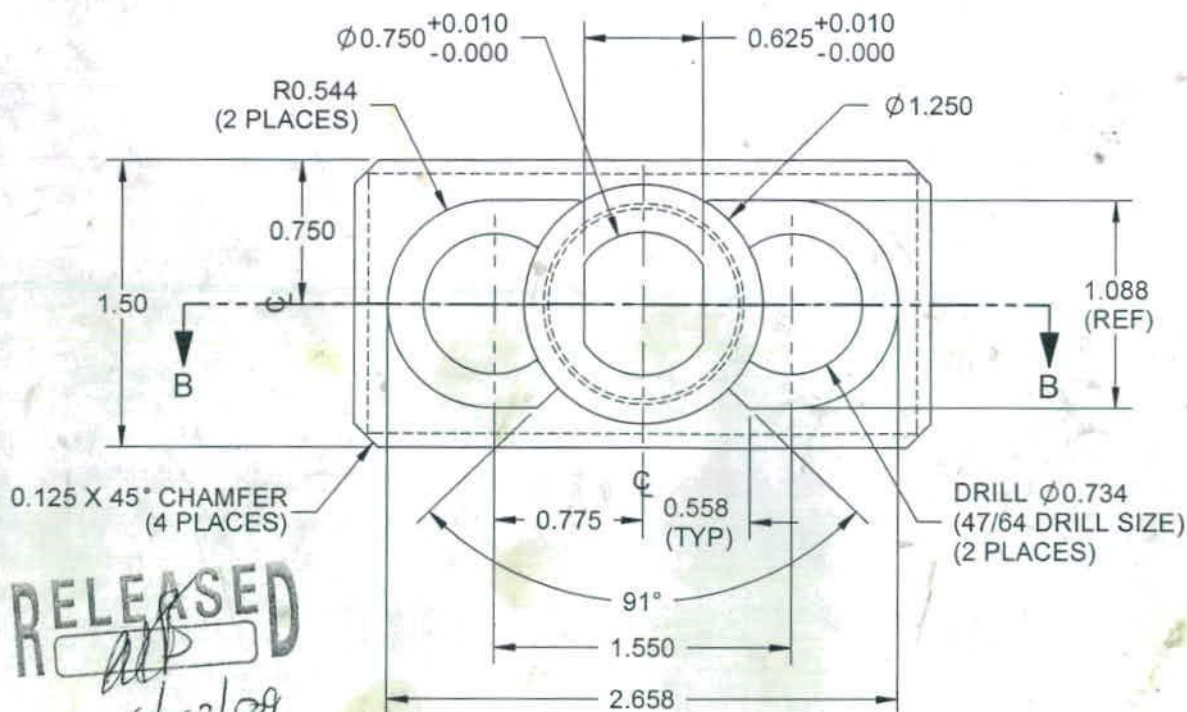
Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	

RELEASED  
05/06/11



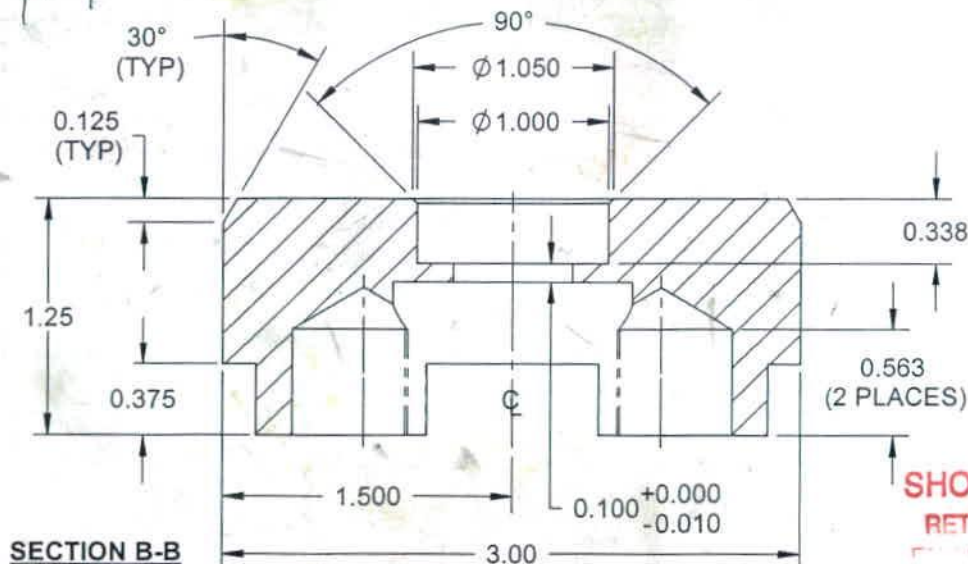


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



RELEASED

05/03/09



SECTION B-B

### D3393-1 CASING

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
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COPY  
RECOMMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 23552

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 10, 2005  
01:45 pm

Work Order No : 0023552  
Project Name : D3393-1  
Project For : WK526  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3393-1  
Description : Battery Lock Casing  
Manufactured : Yes  
Amount Req'd : 50  
Amount Done : 0  
Start Date : 06-10-05  
Est Finish Date : 06-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00